



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB6897875-1
Job Sheet 168854



Part No: RB6897875-1

Job Qty: 6 ea

Part Name: Fuel Nozzle Holding Fixture



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/23/17

Job Tracking No:

Due Date: 12/15/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Air Methods Corporation (CAMET01)

7301 South Peoria Street Englewood, CO, 80112 USA ph:(303) 792-7400

Note: RB6897875 REV.3 IPP REV:A 17.11.21 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/14/17	0.00	0.00	Start Up Large Fab-7		<i>EZ</i>
100	Large Fab	6 pcs		12/14/17	0.00	6.00	Large Fab 4		<i>LZ</i>
110	QC	6 pcs		12/14/17	0.00	0.00	QC9		<i>PD 13-229</i>
120	QC	6 pcs		12/14/17	0.00	0.00	QC5		<i>PD 13-228</i>
122	HandFinish	6 pcs		12/15/17	0.00	3.00	HandFinish7		<i>BFB 15-03-28</i>
124	QC	6 pcs		12/15/17	0.00	0.00	QC5		
130	Outsource	6 pcs		12/15/17	0.00	0.00	Outsource12		<i>CC 18-03-28</i>
140	Packaging	6 pcs		12/15/17	0.00	0.00	Packaging2		<i>APR 11/163</i>
150	QC	6 pcs		12/15/17	0.00	0.00	QC6		<i>11</i>
170	Packaging	6 pcs		12/15/17	0.00	0.00	Packaging3-2		<i>9-89</i>
180	QC21-SA	6 Ea		12/15/17	0.00	0.00	QC21		<i>GA074</i>

Part Op 100 - ASSEMBLE AS PER DWG

Descriptions: 130 - Issue P/O to Groupe Altech; *PO039448* -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

DAS
21
9-89

APR 11 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	98381A172 <i>GA042</i>	6	0	0	0
	IMTM8A <i>GA033</i>	6	0	0	0
	RB6897875-1A <i>5023252</i>	6	0	0	0
	RB6897875-1B <i>CA139</i>	6	0	0	0
	RB6897875-1C <i>packaging</i>	6	0	0	0
	RB6897875-1D <i>CA139</i>	6	0	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	W- ☐ Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. En ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Pc ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐			

Date : _____	Step #: _____	QTY Effective : _____
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Description Work Order Deviation	Disposition

1270 Aberdeen Street
 Cambridge, ON N6A 1K7
 CANADA
 TEL: 1 813 832-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 03/23/18

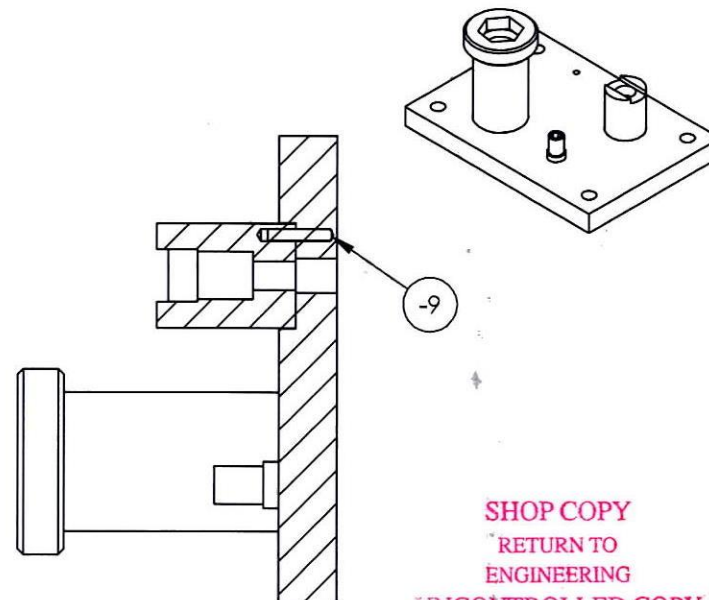
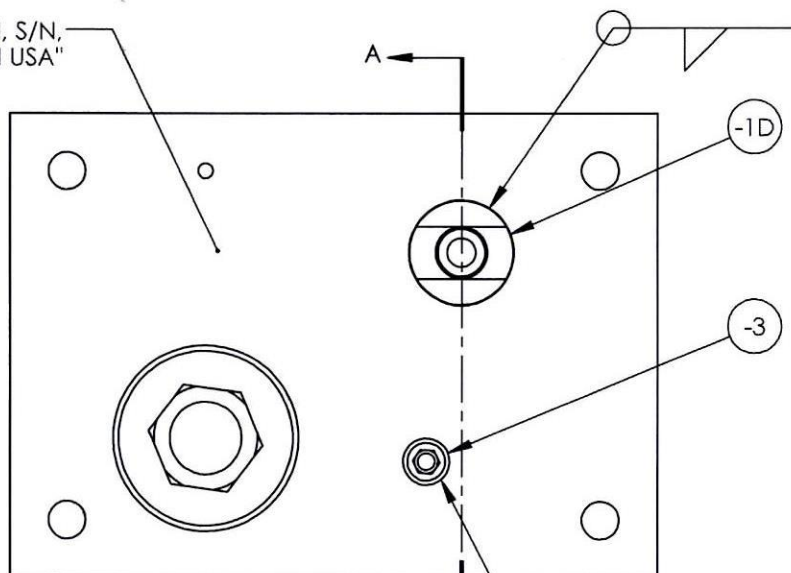
JAKI
 AEROSPACE
 Container No: S054494
 Part: RB6897875 - 1
 Job No: 168854
 Serial No/Batch: S054494
 Revision: 3
 Inspector:

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

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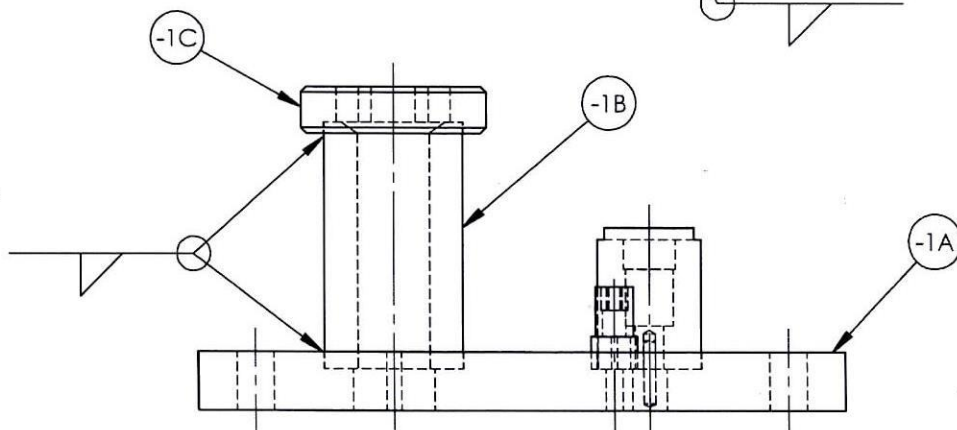
REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1		-1 ADDED WELDMENT.			8/5/2013	RJC	RW
2	16-0176	-1 CH'D DWG. TO SHEET METAL TOLERANCES. ADDED FINISH SPEC. QMSI-6.2.2, B.O. REV D, ADDED P/N-1A.			10/20/2016	RJC	SM
3	17-0100	-1 ADDED ENGRAVE T/N, S/N, "MADE IN USA" NOTE.			4/24/2017	DPD	JAG

ENGRAVE T/N, S/N,
"MADE IN USA"



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168854 MJS
1711-23



WELDMENT

DART AEROSPACE	
TITLE FIXTURE-HOLDING FUEL NOZZLE	
DWG NO. RB6897875-1	REV 3
MAT'L HEAT TREAT FINISH BLACK OXIDE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC QMSI-6.2.2, B.O. REV D	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	ROLLS ROYCE
SCALE 1:2	DATE 9/16/2009
SHEET 2 OF 7	



Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabelled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due	OTHER :							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039448

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039448
PO Date: 3/28/18
Due Date: 4/4/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

				Items							
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
1	168854	RB6897875-1	Fuel Nozzle Holding Fixture Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/4/18	6 pcs	0 pcs	6 pcs	\$17.95/pcs	\$107.70	
						✓ 6x			AT 18/04/03		DAS 11 9-89
2	172194	RBSC7048-P-11	Stud Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/4/18	5 pcs	0 pcs	5 pcs	\$1.45/pcs	\$7.25	
						15x			AT 18/04/03		
3	171742	RBT18520-9	Extension -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/4/18	12 pcs	0 pcs	12 pcs	\$4.35/pcs	\$52.20	
						112x			AT 18/04/03		
4	172193	RBSC7048-P-1	Spring Tensioner Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/4/18	5 pcs	0 pcs	5 pcs	\$1.25/pcs	\$6.25	
						15x			AT 18/04/03		
Grand Total:										\$173.40	

Order Notes



Certificat de Conformité / Certificate of Compliance

(008024-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

008024- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
02-Apr-2018		Aman		PO039448				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RB6897875-1 Rev.	RB6897875-1 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	6	6	0	0	0
2	RBSC7048-P-11 Rev.	RBSC7048-P-11 01 -OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	5	5	0	0	0
3	RBT18520-9 Rev.	RBT18520-9 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	12	12	0	0	0
4	RBSC7048-P-1 Rev.	RBSC7048-P-1 01 -OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	5	5	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.